

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL-ROTOR BRAKE KIT		
Job Number	: 42066			Part Number	: D38213		
Estimate Number	: 13584			Drawing Number	: D38213 PROTOTYPE		
P.O. Number	:			Project Number	:		
This Issue	: 17/09/2008 S.O. No. :			Drawing Revision	: PROTOTYPE		
Prsht Rev.	: NC			Material	: Kydex 6185 (TBD)		
First Issue	: / / Type : R&D THERMOFORMING			Due Date	: 03/10/2008 Qty: 1 Um: EACH		
Previous Run	:			Comment	: Est. A New Issue 08/09/17 DL		
Written By	:						
Checked & Approved By	: JUL 08.9.17						
Comment	:						

Additional Product

SCRAP

PROTOTYPE

Job Number:				
Seq. #:	Machine Or Operation:	Description :		
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING		
				
Comment: HAND FINISHING THERMOFORMING				
	1) Machine set up	M 109398		
		DL 08.09.18		
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING		
				
Comment: HAND FINISHING THERMOFORMING				
	1) Cut sheet to required blank size	DL 08.09.18		
3.0	THERMOFORMING	THERMOFORMING MACHINE		
				
Comment: THERMOFORMING MACHINE				
	Thermoform as per Dwg. D3821-3 and folio (FTA 9054 Prototype) using tool DT 9054			
	Dwg. Rev. <u>A</u>	DL 08.09.18		
	Folio Rev. <u>A</u>			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE		
				
Comment: INSPECT PARTS AS THEY COME OFF MACHINE				
	Visually inspect for proper formation of each part			
	DL 08.09.18			
				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8 	SECOND CHECK <i>BB 08/09/18</i> 
Comment: SECOND CHECK		
6.0	HAND FINISH TH 	HAND FINISHING THERMOFORMING 
Comment: HAND FINISHING THERMOFORMING		
1) Trim to Finished Dimensions <i>080924</i>		
7.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
Check dimensions to ensure conformity to drawing tolerances <i>Engineering Approval</i> <i>08.12.16</i> <i>Scrap</i>		
8.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		
9.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <i>J/J</i>		
10.0	QC21 	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		<i>00251A</i> <i>08.12.16</i>

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries